

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.12**DAILY PROJECT JOURNAL****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Report No:** DPJ-000510**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Dated:** 29-Nov-2007**Location:** Changxing Island, Shanghai, China

**Submittals(New / Total):**      **CWR's:** 0 / 36      **HSR's:** 1 / 18      **NCR's:** 0 / 16

Item	Title	Detail
1	Heat Straightening Requests (HSRs)	HSR (CT)-018 114m Tower Mock-up Interior Splice Plate MUC-A79
2	Major component movement	<p>OBG Production:</p> <p>Welding floorbeams, Splicing T-Stiffeners.</p> <p>77m Tower Mock-up: Performing weld repairs and heat straightening to stiffener plates between diaphragms.</p> <p>89m Tower Mock-up: Welding Longitudinal Stiffener to Skin Plate, Tack Welding of Cross Bracing – ZPMC unaware this was SPCM.</p> <p>114m Tower Mock-up: Fitting Skin Plates to temporary diaphragm.</p> <p>Deck Plate Mock-up: ZPMC performed UT and MT of deck plate splice, QA informed that HSR will be submitted on deck splice due to flatness measurements outside of ZPMC fabrication tolerances.</p>
3	Meetings attended	<p>Caltrans met with ABF and ZPMC at 1300 to discuss issues and the schedule for the next three days.</p> <p>ZPMC would like to confirm their system for marking of RT film. Caltrans, ABF and ZPMC scheduled a meeting tomorrow at 8am to discuss and address any concerns. The current marking system may prove difficult when indexing long welds. Caltrans asked if ABF and ZPMC have addressed the RT testing of thick members (i.e. use of Iridium, Cobalt or liner accelerator). ABF Fabrication Manager David Williams stated the issue was still being addressed.</p> <p>ZPMC informed ABF and Caltrans that the machining of the 89m</p>

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Diaphragms is complete. ZPMC stated it may be one week to arrange transport of the diaphragms back to Changxing Island.

ZPMC informed ABF and Caltrans that Wuxi Boiler will be bending flanges for the floorbeams tomorrow. Caltrans to confirm with ZPMC if QA will be present to perform observations.

ZPMC inquired on the status of CWR's for the Tower Mock-up Stiffener to Skin Plate welds. Caltrans asked if the previous repairs for the stiffeners requiring a 4th time repair were performed in the 1G or 2G position. ZPMC stated the last repairs were performed in the 1G position. Caltrans asked why they were having problems with the repairs. ZPMC explained that the 1st repairs were performed with a WPS with Low Heat Input. This was changed for subsequent repairs. The 2nd repairs were performed in the 2G position which made them difficult to access. The 3rd repairs were performed in the 1G position and the results were much better (defects were smaller than in previous repairs). Caltrans explained that we are trying to help ABF and ZPMC reduce the number of repairs. Caltrans suggested that future repairs are performed in the 1G position, since ZPMC has demonstrated an inability to successfully perform repairs in the 2G position. Caltrans stated that CWR-002, 003, 008 and 009 were approved, and requested notification if ZPMC would be resuming night shift to allow for scheduling. Caltrans stated we still need to meet with ABF about CWR's 026, 028 and 029. Caltrans asked if these welds were performed in the 1G position. After review and internal discussion, ZPMC stated these stiffeners were welded in the 2G position since they welding had already begun prior to ABF requiring ZPMC to stop welding and re-evaluate their fabrication techniques. ZPMC will re-submit the CWR's clarifying the position of welding and cause of defects.

ZPMC asked about the status of HSR-012, 015, 016 and 017. Caltrans stated that ABF was notified these were approved this morning. Caltrans stated that ZPMC has shown a trend of welding stiffeners out of contract tolerance. Caltrans suggest that ABF and ZPMC evaluate the weld sequence and distortion control. ZPMC stated their Production and Technology Departments would meet to discuss methods to reduce distortion.

ZPMC stated they are waiting for WQCP addendum submittal D-15 which has a WPS for welding of the T-Stiffeners. Caltrans confirmed we have received this submittal and are currently reviewing.

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4	Key conversations	QA spoke with ABF Representative Nate Lindell regarding the submittal of Lead QA qualifications for ABF and sub-contracted Bureau Veritas inspectors for supervising the QC on the SPCM Shear Links for the 89m Tower Mock-up. Mr. Lindell is in the process of assembling a submittal.
5	Quality Assurance Inspectors per shift	5 Day Shift (Acuna, Hernandez, Franco, Tracy, Viars) 4 Swing Shift (Berger, Croff, Dixon, Jobes) 0 Graveyard Shift (Cancelled by ZPMC)

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**Inspected By:** McClary,David

Quality Assurance Inspector

**Reviewed By:** Lowry,Patrick

QA Reviewer

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